







Work Order ID 55064




January 5, 2010 2:38:59 PM



Page 1

Item ID: D2945 Accept  Setup Start 
Revision ID: Stop 
Item Name: Step Mounting Plate
Start Date: 05/01/2010 Start Qty: 12.00  Cust Item ID:
Required Date: 15/01/2010 Req Qty: 12.00  Customer:
Reference:

Approvals: Process Plan:  Date: 10-1-05 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2945	Rev A								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2945 Dwg Rev: A Prog Rev: A 02- Deburr if necessary								
6061 .187									
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Deburr \Rightarrow m-k 10/01/26

10-1-13

(23X)

(24)

10-1-13

count
(23)

Pto \Rightarrow

W/O: 55064		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/14	#120	Took Qty #1 For QC inspection template	S	10/1/14	4/	W	S 10/1/14

Part No: D2945 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

Work Order ID 55064

January 5, 2010 2:38:59 PM



Page 2

Item ID: D2945

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Mounting Plate

Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

⇒ M 10-01-22

(X23) φ

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

M113170

Memo

0.00

⇒ M 10-01-25

(X23) φ

Powder Coating

POWDER COAT:

Start Time: 1:45pm

Oven Temperature: 320°C

Finish Time: 2:15pm

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BK 10-01-28

(23) φ

Quality Control

W/O:		WORK ORDER CHANGES					
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January 5, 2010 2:38:59 PM



Page 3

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Accept



Setup Start



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Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 31

0.00



Packaging

Memo

0.00

Packaging

10-1-29

23x51

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/02

MF

10-1-29

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:39:04 PM

Page 1

Work Order ID: 55064



Parent Item: D2945



Parent Item Name: Step Mounting Plate

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rece Site ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.188		Purchased	No			100	sf	7.9811	1.0105	2.1		
6061-T6 .188 Sheet												

13 10-1-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

7.9811

110993

7.9811

110993



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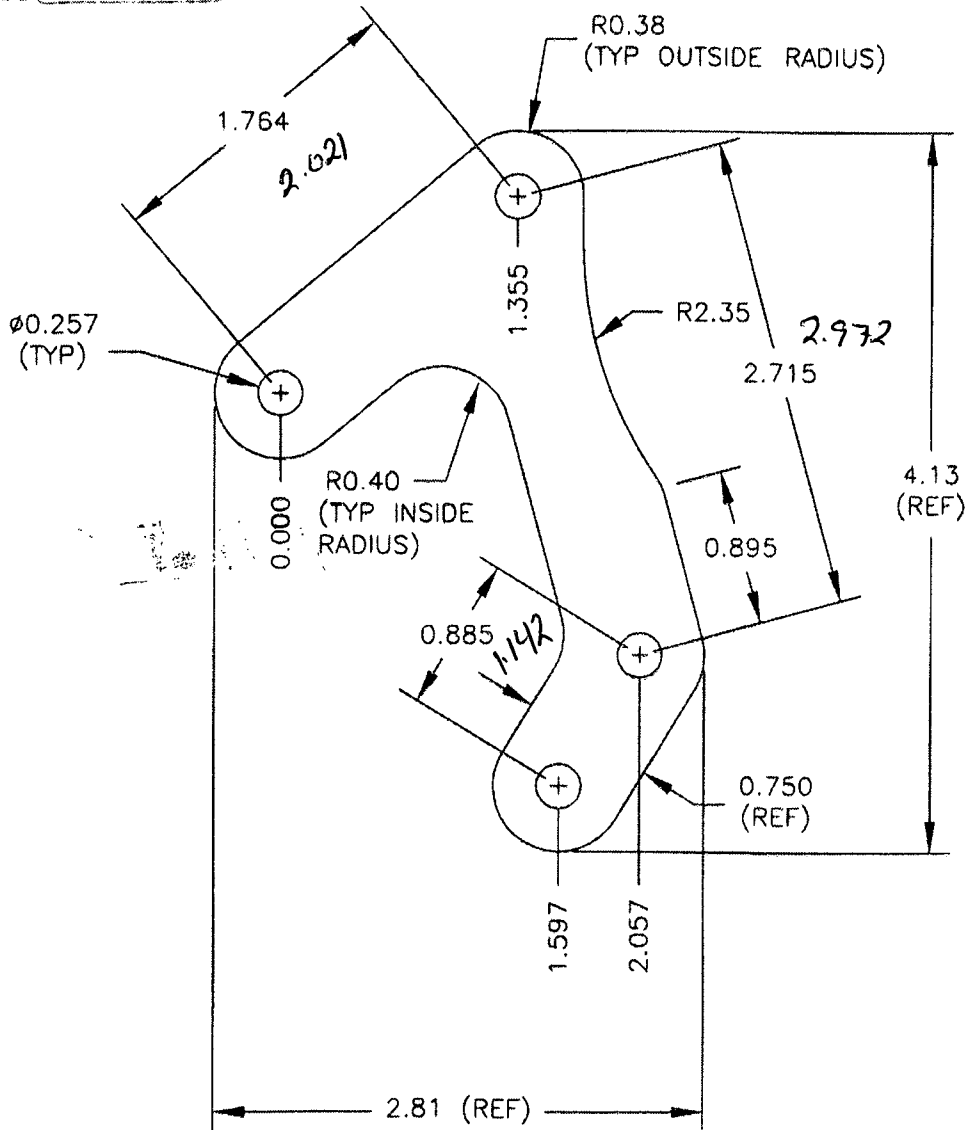
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2945	REV. A SHEET 1 OF 1
DATE 99.12.13		TITLE STEP MOUNTING PLATE	SCALE 1:1
A	99.12.13	NEW ISSUE	

RELEASED
99.12.13



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55064

10-1-05

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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